

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

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1. (Currently Amended) A method of dry milling a material comprising:
providing a milling cutter with a silicon nitride based milling insert;
advancing the milling cutter relative to the material such that at least the majority of
material removal is accomplished by contact with the milling insert;
cutting at a cutting speed of 1000-3000 m/min; and
feeding to a cutting depth of 0.2-2 mm,
wherein the material comprises aluminum and cast iron.

2. (Previously Presented) The method of claim 1, wherein the insert produces
a chip thickness of 0.09-0.17 mm.

3. (Currently Amended) A method of dry milling a composite material, the
method comprising:
providing a milling cutter with a silicon nitride based milling insert;
advancing the milling cutter relative to the material such that at least the majority of
material removal is accomplished by contact with the milling insert;

cutting at a speed of 1100-2500 m/min; and
feeding to a cutting depth of 0.2-2 mm.

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4. (Previously Presented) The method of claim 3, wherein the cutting depth is
0.3-1.0 mm.
